

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025841**Date Inspected:** 10-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG Components				

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Trial Assembly Area

Caltrans and ABF have agreed to conduct visual inspection (VT) and magnetic particle inspection (MT) of welds as part of a special joint inspection program. In response to ZPMC NDT Inspection Notification Sheets (NWIT) #09686 for MT of the following:

This QA Inspector performed random visual testing (VT) and then MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date and provided a turnover to dayshift personnel for tracking of these welds. The members were identified as follows:

OBG Segment 13CW, SEG3015C. The weld designation reviewed was: 138. No apparent VT or MT indications were observed.

OBG Segment 13CW, SEG3015M. The weld designations reviewed were: 157, 158. ZPMC personnel reported no apparent VT or MT indications were observed. No apparent VT indications were observed by this QA Inspector and no MT was performed by this QA Inspector.

OBG Segment 13CW, SEG3015B. The weld designation reviewed was: 266. ZPMC personnel reported no

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apparent VT or MT indications were observed. No apparent VT indications were observed by this QA Inspector and no MT was performed by this QA Inspector.

OBG Segment 13CW, SEG3015D. The weld designation reviewed was: 324. No apparent VT or MT indications were observed.

OBG Segment 13CW, SEG3015K. The weld designation reviewed was: 271. No apparent VT or MT indications were observed.

OBG Segment 13CW, SEG3015L. The weld designations reviewed were: 156, 170, 176. ZPMC personnel reported no apparent VT or MT indications were observed. No apparent VT indications were observed by this QA Inspector and no MT was performed by this QA Inspector.

OBG Segment 13CW, SEG3015J. The weld designation reviewed was: 159. ZPMC personnel reported no apparent VT or MT indications were observed. No apparent VT indications were observed by this QA Inspector and no MT was performed by this QA Inspector.

OBG Segment 13BW, SEG3014H. The weld designation reviewed was: 165. ZPMC personnel reported no apparent VT or MT indications were observed. No apparent VT indications were observed by this QA Inspector and no MT was performed by this QA Inspector.

OBG Segment 13BW, SEG3014D. The weld designation reviewed was: 225. ZPMC personnel reported no apparent VT or MT indications were observed. No apparent VT indications were observed by this QA Inspector and no MT was performed by this QA Inspector.

OBG Segment 13CW, SEG3015G. The weld designations reviewed were: 167, 168. No apparent VT or MT indications were observed. Weld designations 170, 178, 174 were also listed on NWIT #09686 and ZPMC personnel reported no apparent VT or MT indications were observed. No apparent VT indications were observed by this QA Inspector and no MT was performed by this QA Inspector. Weld designations 177, 172, 171 were also listed on NWIT #09686 and ZPMC personnel reported no apparent VT or MT indications were observed. However, weld designation 177 appeared to display weld overlap and required grinding. Paint was not removed in the base metal area within 25mm of the welds. This QA Inspector rejected weld designations 177, 172, 171 for VT based on the above and informed ZPMC QC Xie Gen Lin.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By:	Goulet, George	Quality Assurance Inspector
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Reviewed By:	Riley, Ken	QA Reviewer
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